

CONTROLLED ATMOSPHERE FURNACE AND HEATING METHOD THEREOF

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ABSTRACT OF THE DISCLOSURE

10 In the inventive controlled atmosphere furnace, an  
article 11 conveyed through a preheating chamber 1 prior  
to being brazed is quickly heated with combustion gas  
circulating in a closed-loop flow path through the  
preheating chamber to approximately 450°C within the  
approximately five minutes determined in view of the  
deterioration degree of flux in the atmosphere and the  
15 growth of an oxide layer on the article. A gas burner 71  
and a circulation fan 6 are provided in the closed-loop  
flow path, and the combustion rate of the gas burner and  
the circulation rate of the combustion gas due to the  
circulation fan are controlled based on the chamber  
20 temperature detected by a temperature sensor 9 in the  
preheating chamber.